

# Work Order ID 72642

Wednesday, August 03, 2011 1:53:55 PM



Page 1

Item ID: D4271-025

Accept



Setup Start



Revision ID:

Stop



Item Name: End Fitting Assembly Fwd Beam

Start Date: 8/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4271    | D            |

100

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D4271  
REAM HOLE AS PER DWG  
CUT RIVET AT 1.130"  
C' SINK AT .220" X100 DEG FOR HOLE OPPOSITE TO HEAD

*[Signature]* 8/1/08/10 @

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*[Signature]* 8/1/08/12

120

Identify as per dwg & Stock Location: 0.00



Packaging

Memo

0.00

Packaging

*[Signature]* Line for D407-992-111 kit  
used on W/O 72681

D4271-011

*[Signature]*

**Work Order ID 72642**

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Item ID: D4271-025

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Stop



Item Name: End Fitting Assembly Fwd Beam

Start Date: 8/3/2011 Start Qty: 1.00



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Required Date: 8/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/12

MF  
11-08-12

# Picklist Print

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Page 1

Work Order ID: 72642

Parent Item: D4271-025

Parent Item Name: End Fitting Assembly Fwd Beam

Start Date: 8/3/2011


Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00


Comments: IPP revA 11.07.20 new issue EC veriufied by:JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

|   |  |              |    |  |  |     |      |        |   |   |  |  |  |
|---|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|
| D4149-5<br><br>Eyebolt Stud |  | Manufactured | No |  |  | 100 | Each | 7.0000 | 1 | 1 |  |  |  |
|---|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|


Location Loc Qty Loc Code

ST133 7  
68871 7

|  |  |              |    |  |  |     |      |        |   |   |  |  |  |
|--|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|
| D4419-1<br><br>Fwd Support Plate |  | Manufactured | No |  |  | 100 | Each | 2.0000 | 2 | 2 |  |  |  |
|--|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|


Location Loc Qty Loc Code

ST 2  
72506 2

|  |  |              |    |  |  |     |      |         |   |   |  |  |  |
|--|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|
| D4281-1<br><br>Spacer |  | Manufactured | No |  |  | 100 | Each | 20.0000 | 1 | 1 |  |  |  |
|--|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|

Location Loc Qty Loc Code

ST139 20  
71930 20

|   |  |              |    |  |  |     |      |        |   |   |  |  |  |
|---|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|
| D4281-3<br><br>Spacer |  | Manufactured | No |  |  | 100 | Each | 0.0000 | 1 | 1 |  |  |  |
|---|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|

B 66897  
B 72694 (2x)  
B 72684 (1x)

*Handwritten signatures and dates:*  
8/11/08/09  
8/11/08/09  
8/11/08/09  
8/11/08/10

# Picklist Print

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Work Order ID: 72642

Parent Item: D4271-025

Parent Item Name: End Fitting Assembly Fwd Beam

Start Date: 8/3/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

AN4C13A Purchased No

100 Each

53.0000

2



BOLT

Location

Loc Qty

Loc Code

ST357

53

117793

3

118451

50

MS20427M4-20

Purchased No

100 Each

186.0000

1



RIVET

Location

Loc Qty

Loc Code

ST318

186

118429

186

MS20615-4M18

Purchased No

Each

463.0000

10



Rivet

Location

Loc Qty

Loc Code

ST323

463

117411

93

118077

370

MS21043-4

Purchased No

100 Each

1,057.000

2



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1017

117601

31

117793

486

118378

500

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Shop Packet Print

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# Picklist Print

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Work Order ID: 72642



Parent Item: D4271-025



Parent Item Name: End Fitting Assembly Fwd Beam

Start Date: 8/3/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

100

Each

4,800.000

4

4



Washer

*Handwritten:* 8/11/08/09  
4

Location

Loc Qty

Loc Code

ST297

4800

116900

182

117291

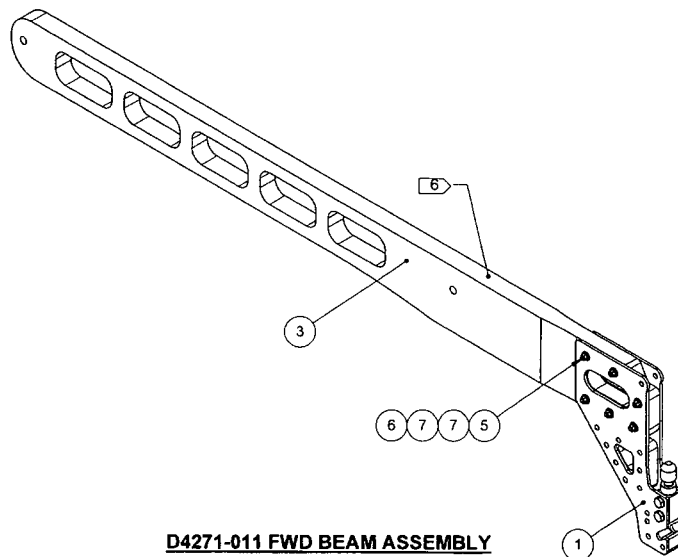
4618

Wednesday, August 03, 2011 1:53:53 PM

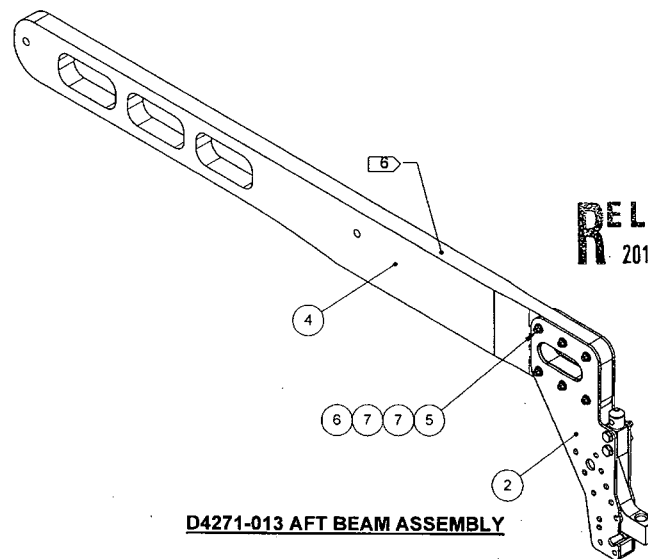
Shop Packet Print

Page 3

| ITEM | QTY<br>-011 | QTY<br>-013 | P/N           | DESCRIPTION                   |
|------|-------------|-------------|---------------|-------------------------------|
|      | X           |             | D4271-011     | FWD BEAM ASSEMBLY             |
|      |             | X           | D4271-013     | AFT BEAM ASSEMBLY             |
|      | -           | -           | D4271-021     | DELETED AT REVISION D         |
|      | -           | -           | D4271-023     | DELETED AT REVISION D         |
| 1    | 1           | -           | D4271-025     | FWD BEAM END FITTING ASSEMBLY |
| 2    | -           | 1           | D4271-027     | AFT BEAM END FITTING ASSEMBLY |
| 3    | 1           | -           | D4275-1       | FWD BEAM                      |
| 4    | -           | 1           | D4276-1       | AFT BEAM                      |
| 5    | 6           | 6           | AN3C12A       | BOLT                          |
| 6    | 6           | 6           | MS21043-3     | NUT                           |
| 7    | 12          | 12          | NAS1149C0332R | WASHER                        |



**D4271-011 FWD BEAM ASSEMBLY**



**D4271-013 AFT BEAM ASSEMBLY**

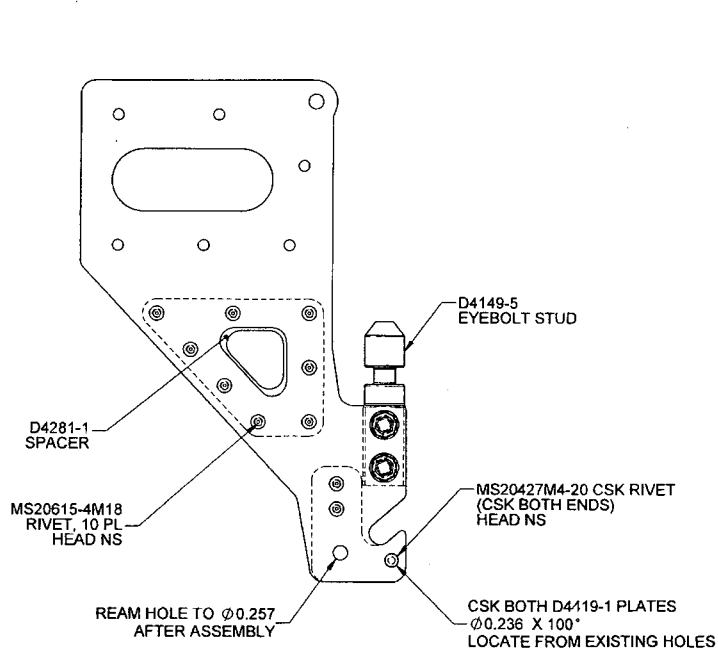
**RELEASED**  
2011-07-28

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-0XX" AND B/N "BXXXXX"  
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT -011: 11.02 lbs  
-013: 12.97 lbs

|            |  |  |              |
|------------|--|--|--------------|
| D          | DELETED -021 & -023 REPLACED BY -025 & -027 FOR Q.R. STEP INSTALLATION.                    | AJS  | 11.07.14     |
| C          | ADDED -021 & -023 FOR EASE OF CONFIGURATION MANAGEMENT. REFORMAT SEE PREV REV FOR DETAILS. | AJS  | 11.07.12     |
| B          | ITEM 10 CHANGED FROM AN3C12A TO AN4C13A  | SC   | 10.12.01     |
| A          | NEW ISSUE  | SC   | 10.11.25     |
| REV.       | DESCRIPTION  | BY   | DATE         |
| DESIGN     | JPH  | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | AJS  |  |              |
| CHECKED    | <i>[Signature]</i>   | DRAWING NO.  | REV. D       |
| MFG. APPR. | <i>[Signature]</i>   | <b>D4271</b>   | SHEET 1 OF 3 |
| APPROVED   | <i>[Signature]</i>   | TITLE  | SCALE        |
| DE APPR.   | <i>[Signature]</i>   | <b>SUPPORT BEAM ASSEMBLIES</b>   | NTS          |
| DATE       | 11.07.14   | <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD<br/> THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |              |

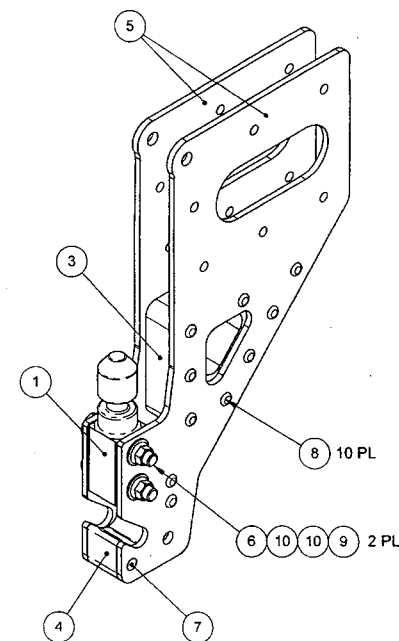
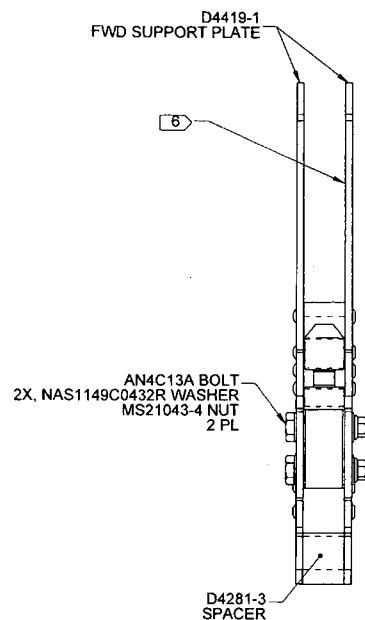
| ITEM | QTY<br>-025 | P/N           | DESCRIPTION                   |
|------|-------------|---------------|-------------------------------|
|      | X           | D4271-025     | FWD BEAM END FITTING ASSEMBLY |
| 1    | 1           | D4149-5       | EYEBOLT STUD                  |
| 3    | 1           | D4281-1       | SPACER                        |
| 4    | 1           | D4281-3       | SPACER                        |
| 5    | 2           | D4419-1       | FWD SUPPORT PLATE             |
| 6    | 2           | AN4C13A       | BOLT                          |
| 7    | 1           | MS20427M4-20  | CSK RIVET (MONEL)             |
| 8    | 10          | MS20615-4M18  | RIVET (MONEL)                 |
| 9    | 2           | MS21043-4     | NUT                           |
| 10   | 4           | NAS1149C0432R | WASHER                        |



**D4271-025 FWD BEAM END FITTING ASSEMBLY**

**NOTES:**

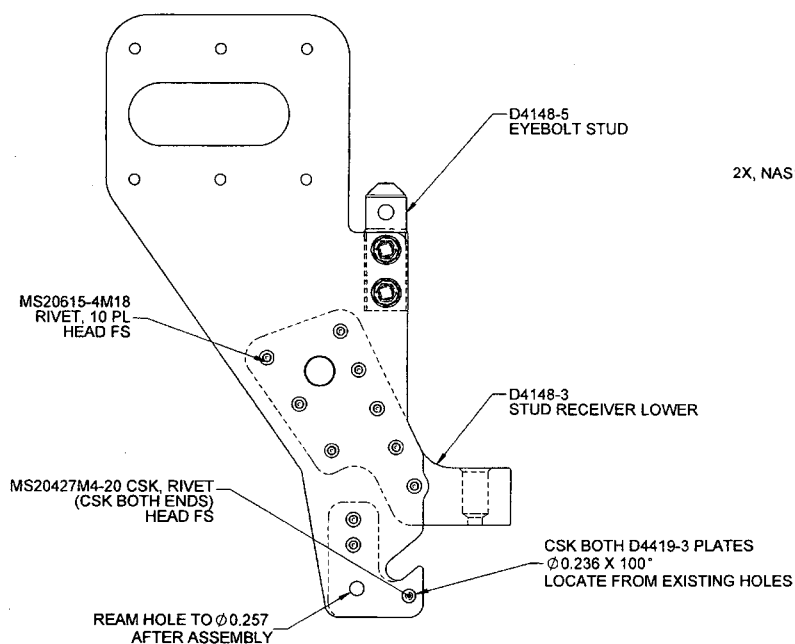
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-025" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 2.69 lbs



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2011-07-28

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|------------|----------|---|
| DESIGN     | JPH      | <b>DART AEROSPACE LTD</b>   |
| DRAWN      | AJS      | HAWKESBURY, ONTARIO, CANADA   |
| CHECKED    |          | DRAWING NO. <b>D4271</b> REV. D   |
| MFG. APPR. |          | SHEET 2 OF 3  |
| APPROVED   |          | TITLE <b>SUPPORT BEAM ASSEMBLIES</b> SCALE NTS  |
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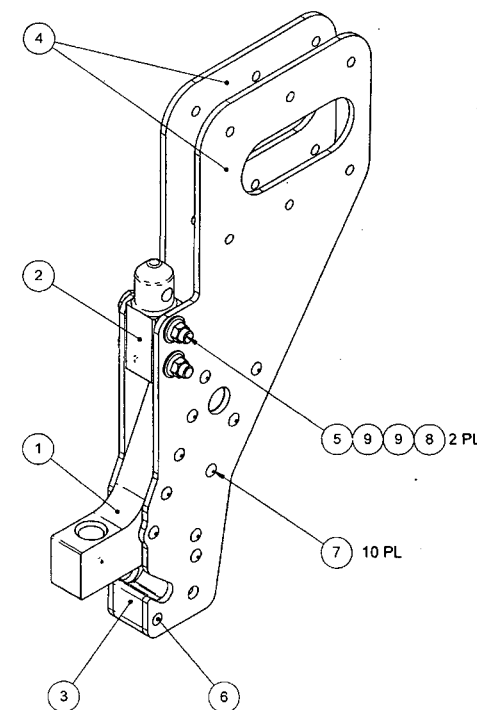
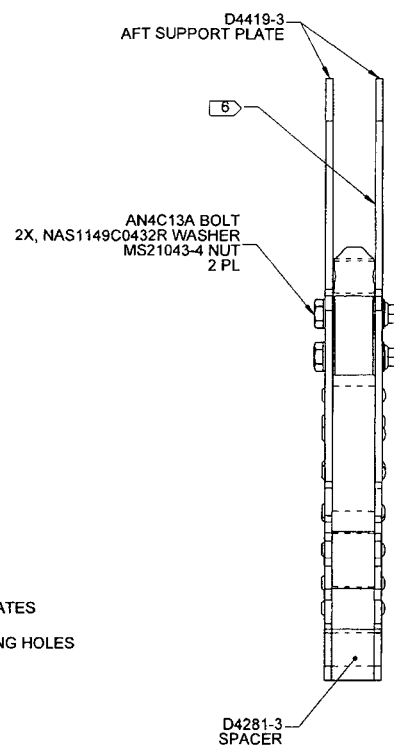
| ITEM | QTY<br>-027 | P/N           | DESCRIPTION                   |
|------|-------------|---------------|-------------------------------|
|      | X           | D4271-027     | AFT BEAM END FITTING ASSEMBLY |
| 1    | 1           | D4148-3       | STUD RECEIVER LOWER           |
| 2    | 1           | D4148-5       | EYEBOLT STUD                  |
| 3    | 1           | D4281-3       | SPACER                        |
| 4    | 2           | D4419-3       | AFT SUPPORT PLATE             |
| 5    | 2           | AN4C13A       | BOLT                          |
| 6    | 1           | MS20427M4-20  | CSK RIVET (MONEL)             |
| 7    | 10          | MS20615-4M18  | RIVET (MONEL)                 |
| 8    | 2           | MS21043-4     | NUT                           |
| 9    | 4           | NAS1149C0432R | WASHER                        |



**D4271-027 AFT BEAM END FITTING ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-027" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 4.25 lbs



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2011-07-28

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | JPH      | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      | AJS      | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    |          | DRAWING NO.  | REV. D       |
| MFG. APPR. |          | <b>D4271</b>   | SHEET 3 OF 3 |
| APPROVED   |          | TITLE  | SCALE        |
| DE APPR.   |          | <b>SUPPORT BEAM ASSEMBLIES</b>   | NTS          |
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